

# Work Order ID 61843

Tuesday, September 07, 2010 3:19:57 PM



Page 1

Item ID: D3502-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 9/7/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 10-9-08 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3502

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 3.475 " long 1 BLANK MAKES 2 PARTS

*OK 10/09/25*

12 *[initials]*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA649 Rev: *AA* & Dwg D3502 Rev: *B* 2-Deburr  
per dwg D3502

*OK 10/09/30*

12 *[initials]*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*OK 10/09/30*

12 *[initials]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 61843**

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00							
140  Small Fab Small Fab	Small Fab  Memo Mark hole position using DT9430□Drill as per Dwg D3502.	0.00  0.00							
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00							

B.A 10/10/01

9510/10/05 (12)

10-10-6

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Revision ID:

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Start Date: 9/7/2010 Start Qty: 12.00

Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/12

MF  
10-10-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

Tuesday, September 07, 2010 3:20:08 PM

Page 1

Work Order ID: 61843



Parent Item: D3502-1



Parent Item Name: Support

Start Date: 9/7/2010

Required Date: 9/13/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-07-06 JLM  
IPP Rev:B Add tooling hole 07-03-28  
Esr rev C added DT9430 08.11.03 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased		No		100	f	73.4494	0.289	3.650526			
6061-T6 Bar 1.00 x 4.00													

Location

Loc Qty

Loc Code

MAT03

73.4494

107221

58.58

→ 114352

14.8694

3.6505 ml 10/09/25

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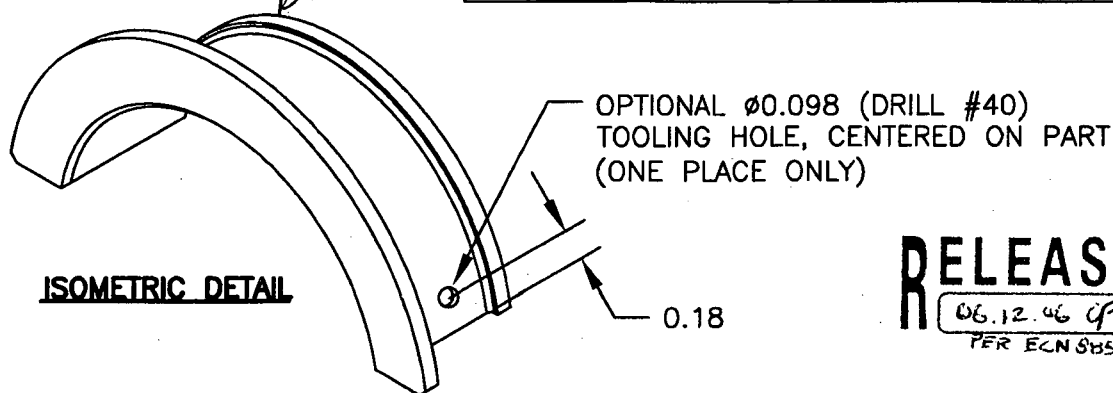
SHOP COPY

**DART**

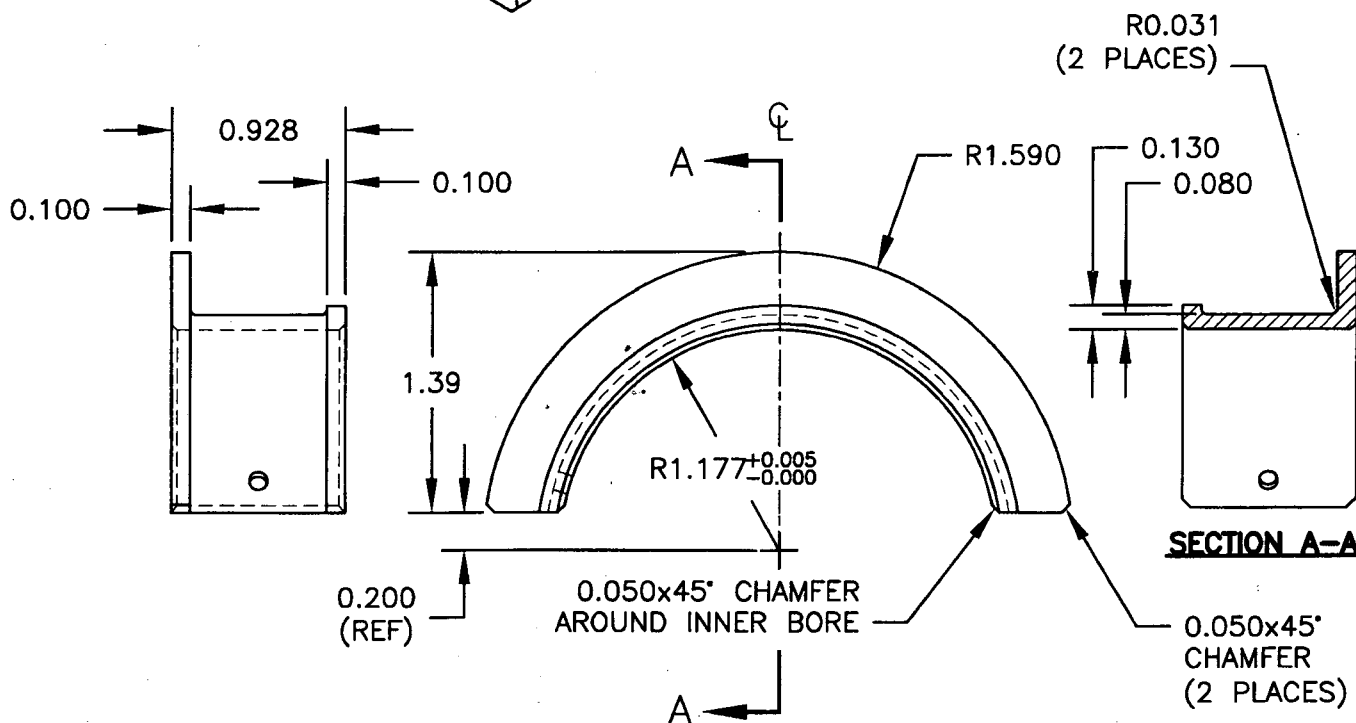
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 61843 010-9-08

DESIGN <u>QP</u>	DRAWN BY <u>QP</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <u>///</u>	APPROVED <u>///</u>	DRAWING NO. D3502	REV. B SHEET 1 OF 1
DATE 06.10.31	TITLE SUPPORT		SCALE 1:1
A	06.04.18	NEW ISSUE	
B	06.10.31	ADD TOOLING HOLE FOR FINISHING	



**RELEASED**  
06.12.06 QP  
PER ECN 885



### D3502-1 SUPPORT

- 1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ±0.010, X.XX = ±0.030) UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

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